

Date: Tuesday, 21/10/2008 2:45:26 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 EXTRUSION BENDING
Job Number	: 42769		
Estimate Number	: 10311		
P.O. Number	:	Part Number	: D2620
This Issue	: 21/10/2008 S.O. No. :	Drawing Number	: D2620 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SKIDTUBES	Drawing Revision	: B
Previous Run	: 41820	Material	:
Written By	:	Due Date	: 10/11/2008
Checked & Approved By	: <u>JUD 08-10-21</u>	Qty:	12 Um: Each
Comment	: Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26001160	Extrusion Round 3" 206
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) Extrusion Round 3" 206 Pick; Qty Part Number Description Batch 1 D2600-1 Extrusion Round 3"206 34715		
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2- Cut Fwd end of tube as per Dwg D2620		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: Skid tubes		
5.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

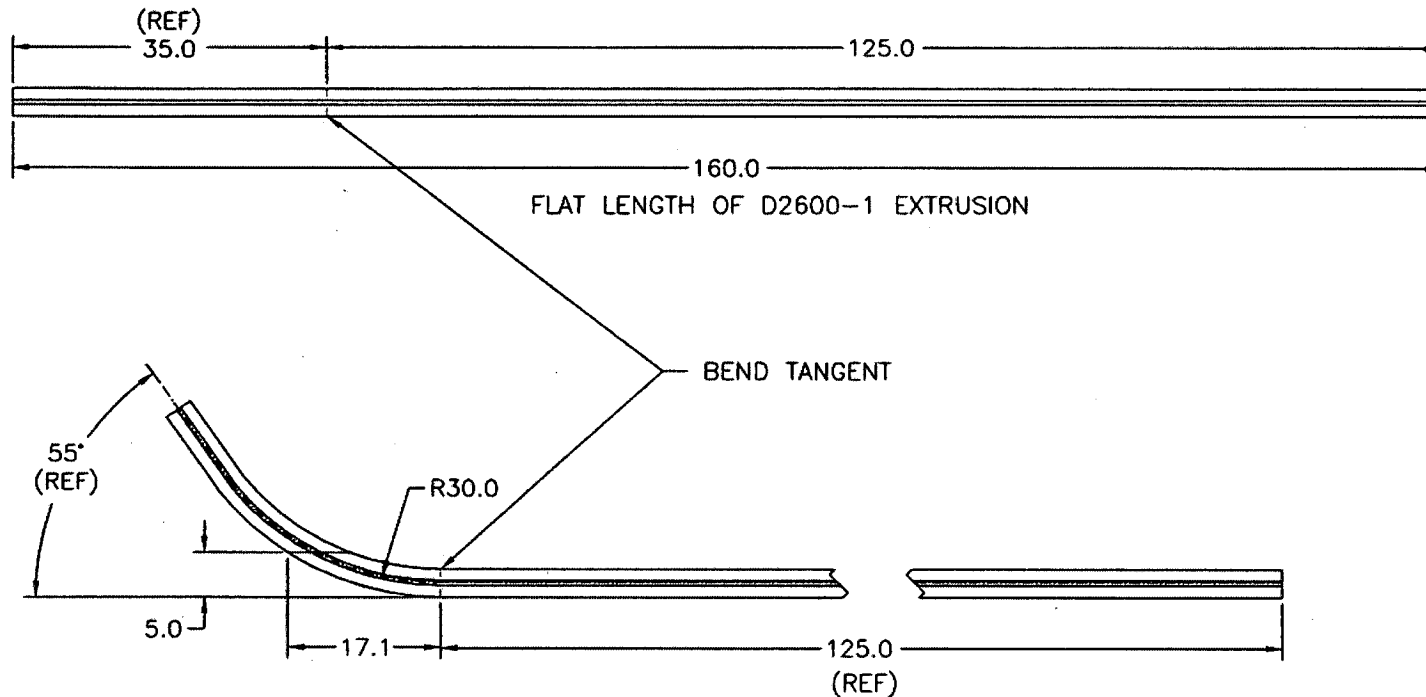
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES



DESIGN	RT	DRAWN BY	RT	DART AEROSPACE USA, INC.
CHECKED	RT	APPROVED	KE	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	99.09.10	DRAWING NO.	D2620	REV. B
		TITLE	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
				SCALE 1:20
A	97.11.07	NEW ISSUE		
B	97.09.10	UPDATE FOR IN-HOUSE BENDING		

RELEASED
49.04.15 DS